

Date: Thursday, 11/29/2007 11:09:58 AM
 User: Kim Johnston

Process Sheet

52

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE
 Job Number : 36057
 Estimate Number : 10973
 P.O. Number : N/A Part Number : D206667203
 This Issue : 11/29/2007 S.O. No. : N/A Drawing Number : D206-667-243 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : B
 Previous Run : 36056 Material : N/A
 Due Date : 12/24/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: 05.09.01 Add holes for compatibility with Bell
 Skidtubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

KS 07.12.07

2.0 D6004115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube B32305

Check OD = 2.500"; ID = 1.800"

J.F. 07/12/07

①

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

J.F. 07/12/07

①

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/07

①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36057

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243
Inside of Cuff(Donot engrave on outside of tube)

J.F. 07/12/07 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/07 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/12/07 ①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWM

07-12-10

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP

7-12-10

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

EL/JO 7-12-10

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

EL 7-12-10

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36057

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

5-11/12/10 (K)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size, using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

SR
7-12-10

AWM
07-12-11

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM
07-12-11

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5-11/12/13 (K)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5-11/12/13 (K)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36057

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 3299

C 2071121170

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

2/12/17

①

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

12-10

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

RS 07-12-15

3-Paint outside crosstube with White Imron as per QSI 005 4.2

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

12 17

①

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-045

Nut Plate

34077

RS 07-12-15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36057

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

33422

34061

2008/11/9

RT 07-12-15

24.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

104885

RT 07-12-15

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 07-12-15

26.0

~~D2856400~~ D2856 600

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s) (cut to 4")

Pick:

Qty Part number Description Batch

2 D2856-400 (Cut to 7.75")

Abrasion Strip

25656

MM 07 12 17

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support

34063

MM 07 12 17

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

105066

MM 07 12 17

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36057

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

M
07 12 17 (1)

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/12/21 (1)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105408

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105430

SC

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt M104679

SC

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

7/12/27 SC (14)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PA# _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:09:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36057

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-32A

Bolt

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M101156 7/12/27 SD 12

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

Rev C

1804/12/27

(K1)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D208101/03

Job Completion



mi 2008/1/3

W

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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|---|--|---------------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 36057 |
| Description: Crosstube Assembly | | Part Number: | D206-667-243 |
| Inspection Dwg: D206-667-243 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

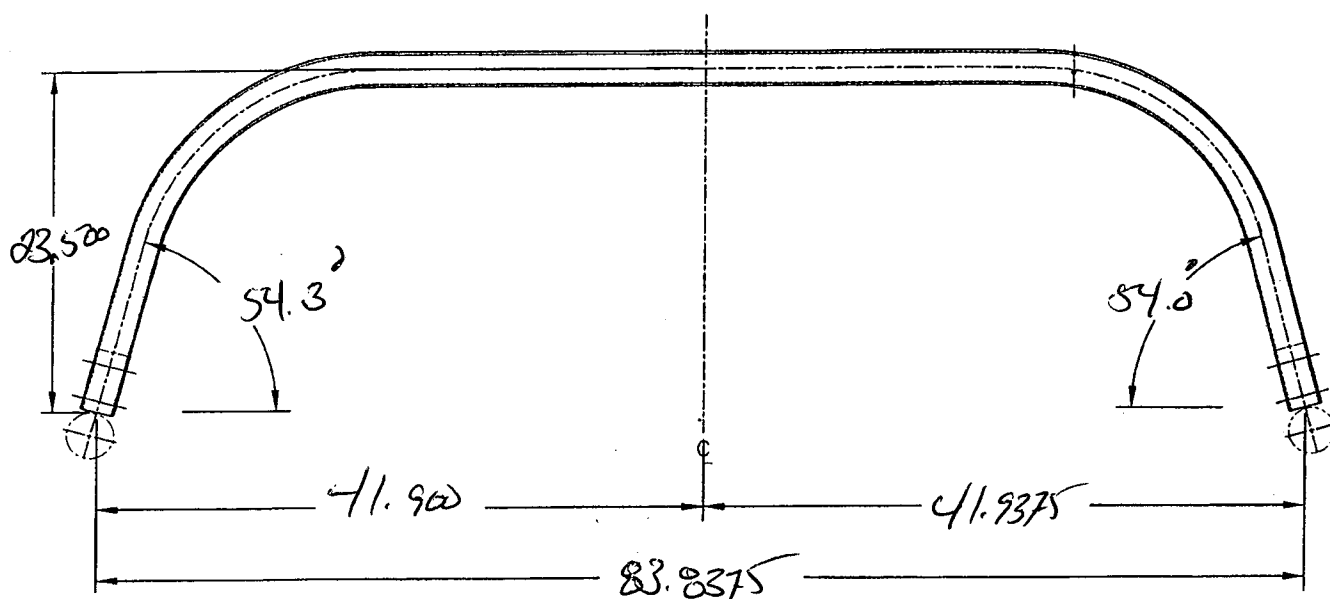
| Inspection Sheet Drawing Dimension | | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------------------|-------------|---------------|------------------|--------|--------|----------------------|----------|
| SIDE A | 2.490 | +0.005/-0.000 | 2.494" | ✓ | | | |
| | 2.018 | +0.005/-0.000 | 2.023" | ✓ | | | |
| | 2.079 | +0.005/-0.000 | 2.084" | ✓ | | | |
| | 2.145 | +0.005/-0.000 | 2.150" | ✓ | | | |
| | 2.209 | +0.005/-0.000 | 2.214" | ✓ | | | |
| | 2.287 | +0.005/-0.000 | 2.290" | ✓ | | | |
| | 2.363 | +0.005/-0.000 | 2.365" | ✓ | | | |
| | 2.433 | +0.005/-0.000 | 2.436" | ✓ | | | |
| | 0.200 | +/-0.010 | 0.200" | ✓ | | | |
| | 0.500 x 30° | +/-0.010 | 0.500 x 30° | ✓ | | | |
| | R0.063 | +/-0.010 | R0.063" | ✓ | | | |
| | R0.500 | +/-0.010 | R0.500" | ✓ | | | |
| | 4.438 | +/-0.030 | 4.446" | ✓ | | | |
| | | | | | | | |
| | | | | | | | |
| SIDE B | 104.91 | +/-0.020 | 104.910" | ✓ | | | |
| | 2.490 | +0.005/-0.000 | 2.494" | ✓ | | | |
| | 2.018 | +0.005/-0.000 | 2.023" | ✓ | | | |
| | 2.079 | +0.005/-0.000 | 2.084" | ✓ | | | |
| | 2.145 | +0.005/-0.000 | 2.150" | ✓ | | | |
| | 2.209 | +0.005/-0.000 | 2.214" | ✓ | | | |
| | 2.287 | +0.005/-0.000 | 2.290" | ✓ | | | |
| | 2.363 | +0.005/-0.000 | 2.364" | ✓ | | | |
| | 2.433 | +0.005/-0.000 | 2.436" | ✓ | | | |
| | 0.200 | +/-0.010 | 0.200" | ✓ | | | |
| | 0.500 x 30° | +/-0.010 | 0.500 x 30° | ✓ | | | |
| | R0.063 | +/-0.010 | R0.063" | ✓ | | | |
| | R0.500 | +/-0.010 | R0.500" | ✓ | | | |
| | 4.438 | +/-0.030 | 4.441" | ✓ | | | |
| | | | | | | | |

| | | | | | |
|---------------------|----------|--------------------|----------|----------------------------|-----|
| Measured by: | J.F. | Audited by: | J.F. | Prototype Approval: | N/A |
| Date: | 07/12/07 | Date: | 07/12/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 06.09.01 | New Issue (P/O D206-667-203) | KJ/JLM | |

| | | | |
|--|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 36057 |
| Description: Crosstube High Aft (206L) | | Part Number: | D206-667-203 |
| Inspection Dwg: D206-667-243 Rev: B | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 23.46 | 23.58 |
| 1/2 Span | 41.86 | 41.98 |
| Angle | 54 | 56 |
| Total Span | 83.72 | 83.96 |



| Comments |
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|-----------------|---------|
| QC15 Inspection | |
| Date | 2/12/10 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | |



| | | | |
|------------------|------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # DS | APPROVED # DS | DRAWING NO. D206-667-243 | REV. B SHEET 1 OF 3 |
| DATE 05.07.26 | | TITLE CROSSTUBE ASS'Y (206L HIGH AFT) | SCALE NTS |
| A | 00.11.17 | NEW ISSUE | |
| B | 05.07.26 | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |

RELEASED
05-07-26

UNDER REVIEW

06-08-10 RH

12 draw detail F

RH
07.05.02

| Qty | Part Number | Description |
|-----|---------------|--------------------------|
| X | D206-667-243 | CROSSTUBE ASSEMBLY |
| 1 | D6004-115 | CROSSTUBE |
| 2 | D2856-400-773 | ABRASION STRIP |
| 2 | D2873-043 | NUT PLATE |
| 2 | D2873-045 | NUT PLATE |
| 2 | D2892-1 | SUPPORT |
| 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 4 | MS21920-22 | CLAMP |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY

RETURN TO

ENGINEERING

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SUBJECT TO AMENDMENT

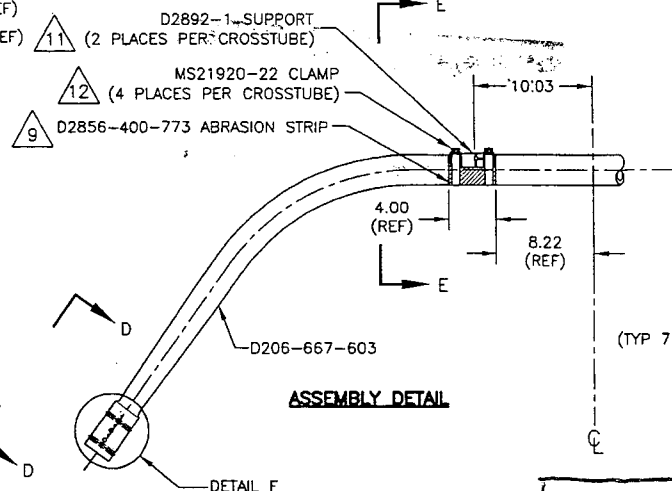
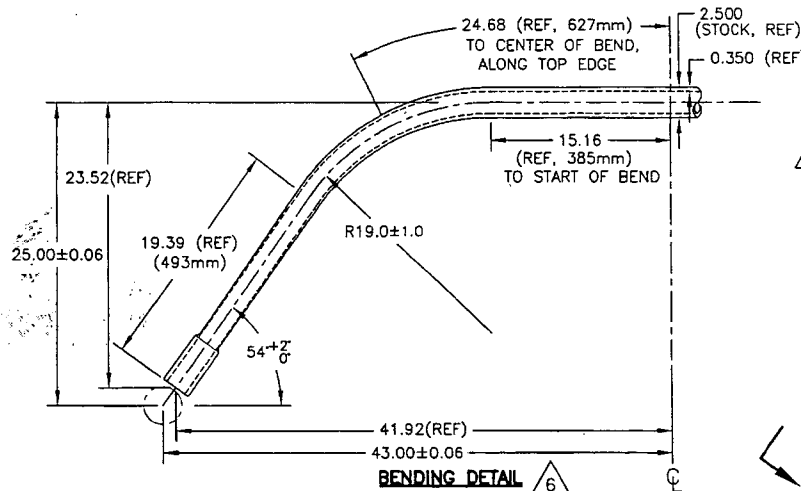
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WORK ORDER

NO. 36057

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△ B $\varnothing 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001 OF HOLE ON OTHER SIDE OF CUFF

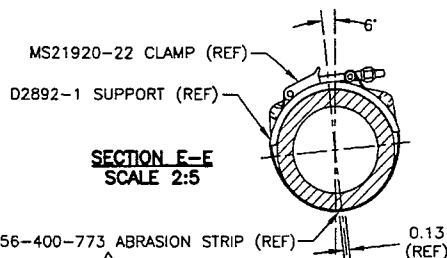
PILOT $\varnothing 0.128$
C'SINK $\varnothing 0.225 \times 1.00$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

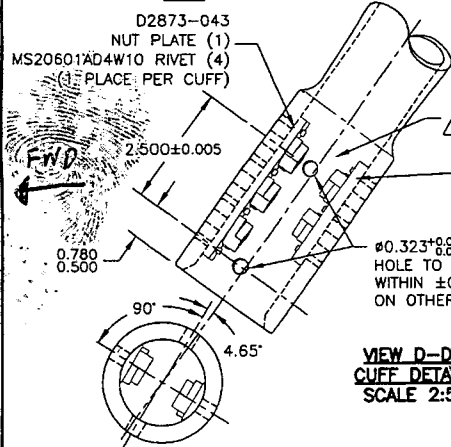
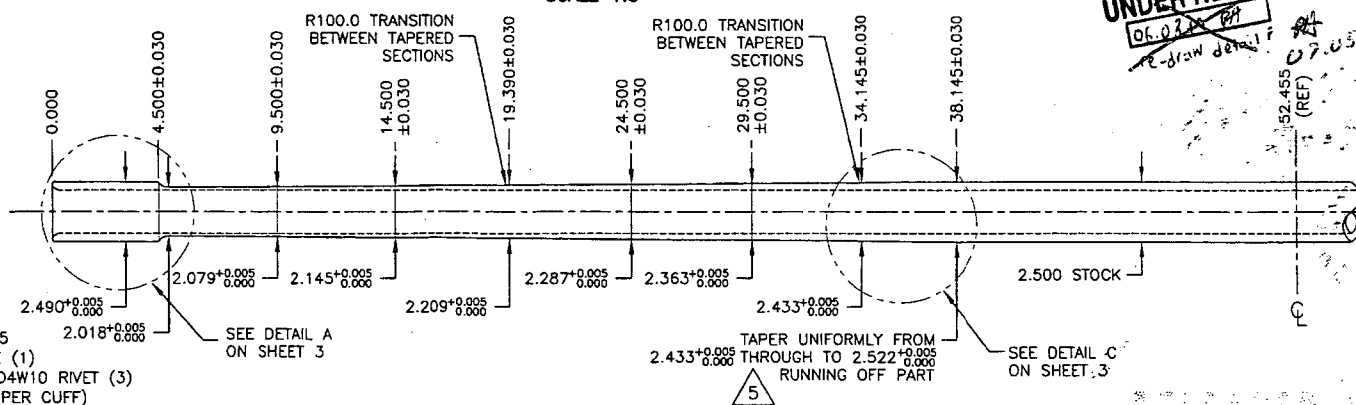
DETAIL F
SCALE 2:5

UNDER REVIEW
06.04.26 PH
re-draw detail

FWD SIDE ONLY



TURNING DETAIL
SCALE 1:5



VIEW D-D:
CUFF DETAIL
SCALE 2:5

$\varnothing 0.323^{+0.005}_{-0.000}$
HOLE TO BE ALIGNED
WITHIN ± 0.001 OF HOLE
ON OTHER SIDE OF CUFF

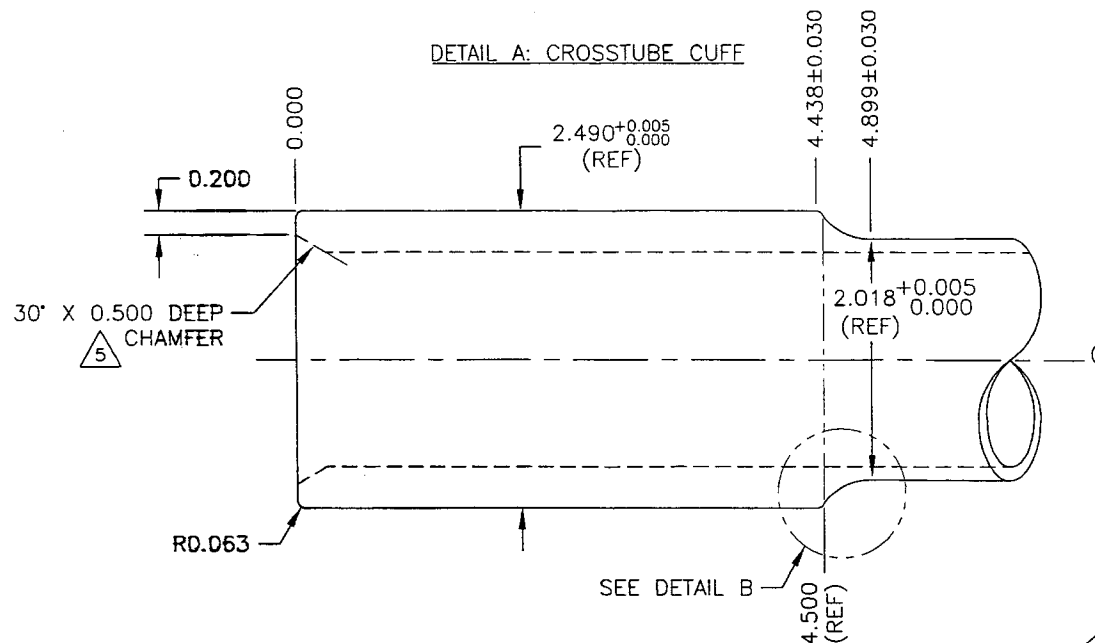
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| | | | |
|------------------|----------------|--|--|
| DESIGN PH | DRAWN BY PH | DART | DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA |
| CHECKED DS | APPROVED DS | DRAWING NO. D206-667-243 | REV. B SHEET 2 OF 3 |
| DATE 05.07.26 | | TITLE CROSSTUBE ASS'Y (206L HIGH AFT) | SCALE 1:10 |

DETAIL A: CROSSTUBE CUFF



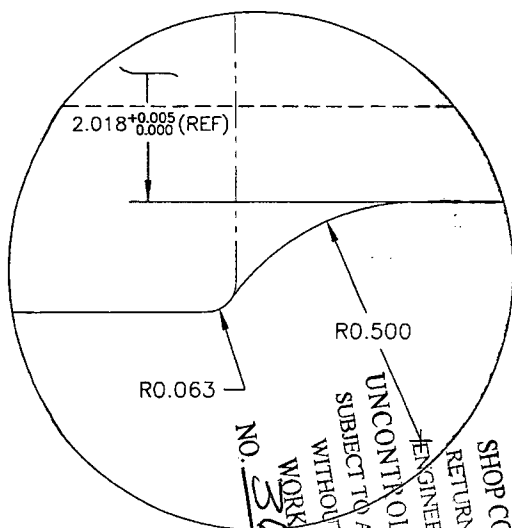
05.07.26 #

UNDER REVIEW

06.03.06 PH

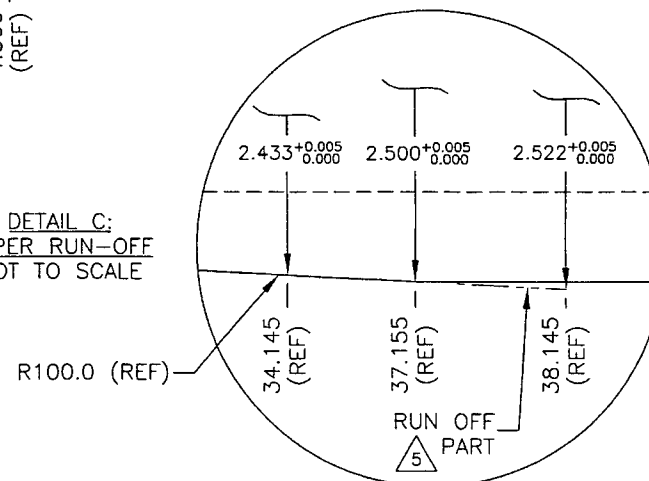
Re-draw detail

PH 07.05.02



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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| | | CHECKED | APPROVED | DRAWING NO. | SHEET 3 OF 3 | |
| | | DS | DS | D206-667-243 | | |
| | | DATE | TITLE | | SCALE | |
| | | 05.07.26 | CROSSTUBE ASS'Y (206L HIGH AFT) | | 1: | |



LIQUID PENETRANT TEST REPORT

P - 7-1055

PAGE 1 OF 1

TIME AM ☐ PM ☐

CLIENT DART AREOSPACE
ATTENTION LINDA LACELLE
ADDRESS 1270 ABERDEEN ST. HAWKESBURY ONT.

DATE DEC. 14, 2007
ACUREN JOB No. 188-7-01055
PO/NO. 5299
WORK LOCATION HAWKESBURY
ACCEPTANCE STD. ASTM 1417/QSI-038

REV./DATE 2005

PROJECT 212/205 HIGH FED X-TUBE, 206L FWD X-TUBES, 206BAFT X-TUBES, 206L AFT X-TUBES
ITEM(S) EXAMINED JOB #S 35725, 35893, 36051, 36053, 36055, 36056, 36057, 36059.

JOB DESCRIPTION PROCEDURE No. LT-0002 REV./DATE TECHNIQUE No. LT-0002-02 REV./DATE
Part No. D206667201, D206667203, D212664101, D206667103 Material ALODYNED ALUMINUM Thickness
Scope WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.

TEST DETAILS

| | | | | | |
|-------------------|---|----------------------------------|--|---|--|
| Method | <input checked="" type="checkbox"/> Fluorescent | <input type="checkbox"/> Visible | <input checked="" type="checkbox"/> Water Wash | <input type="checkbox"/> Solvent Removable | <input type="checkbox"/> Post Emulsified |
| Family Brand | MAGNAFLUX | | Black Light S/N 8178 | <input checked="" type="checkbox"/> Output > 1000 μ W/cm ² | <input checked="" type="checkbox"/> Ambient < 2 fc |
| Penetrant | ZL67 | Minimum Dwell time 45 Min. | Lighting Equip. <input checked="" type="checkbox"/> Flashlight <input type="checkbox"/> Troublelight | <input checked="" type="checkbox"/> Output > 100 fc @ surface | |
| Penetrant Remover | H20 | Minimum Dry time > 10 Min. | Other | | |
| Developer | SKDS2 | Minimum Dwell time 10 Min. | Light Meter S/N | Cal Due Date | MAR 08 |
| Developer Type | <input checked="" type="checkbox"/> Non Aqueous | <input type="checkbox"/> Aqueous | <input type="checkbox"/> Dry | | |

TEST SURFACE

| | | | | | |
|---------------------|---|---|---|---------------------------------------|---|
| Surface Condition | <input checked="" type="checkbox"/> As Ground | <input type="checkbox"/> As Welded | <input checked="" type="checkbox"/> Machined | <input type="checkbox"/> Shot Blasted | <input type="checkbox"/> Clean Bare Metal |
| Surface Temperature | <input type="checkbox"/> < - 4°C/ 20°F | <input type="checkbox"/> - 4°C/ 20°F to 10°C/50°F | <input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F | | <input type="checkbox"/> > 52°C/125°F |

RESULTS- (☐ METRIC ☐ IMPERIAL)

| Item | Comments | Accept | Reject |
|---|----------|--------|--------|
| F.L.P.I. CARRIED OUT ON 100% OF EXTERNAL SURFACE OF: 212/205 HIGH FED X-TUBES JOB# 35893 206B AFT X-TUBES JOB #S 36051, 35725 206L FWD X-TUBES JOB#S 36053, 36055 206L AFT X-TUBES JOB #S 36057, 36059, 36056 RESULTS: 206B AFT X-TUBE #36051 HAS ROUGH GRINDING MARKS. TO BE POLISHED AND RECHECKED AT A LATER DATE. ALL OTHER JOB #S ARE ACCEPTABLE TO ASTM 1417/ QSI-038 STANDARD. | | | |

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

| Client Representative | | DTR # | |
|-------------------------|-------------------|---------------------|----------|
| Technician (Signature): | | Report Reviewed by: | |
| Name (Print): | FREDERICK CHAGNON | Name | initials |
| CGSB Level | II | CGSB Level | II |
| CGSB Reg. No | 10560 | CGSB Reg. No | 12247 |

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